

Work Order ID 110148

December-17-13 9:16:18 AM

110148

Page 1

Item ID: D3296-041
 Revision ID:
 Item Name: Replacement Interior Door For -111
 Start Date: 12/17/13 Start Qty: 6.00 *6*
 Required Date: 12/17/13 Req'd Qty: 6.00 *6*
 Reference:

Accept ***N900040100*** Setup Start ***NS1***
 Stop ***NS2***
 Cust Item ID:
 Customer:

Approvals: Process Plan: MLJ Date: 12-12-18
 QC: _____ Date: _____

Tooling: _____ Date: _____
 SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3296	B								

100
100
 Small Fab
 Small Fab
 Small Fab
 Small Fab
 Small Fab
 Memo
 Fabricate & assemble as per Dwg D3296.
 Tranfer drill using DT8470 & DT9521

0.00
 0.00
 8x
 11/03/17
 DAS 36 9-89

110
110
 QC
 Quality Control
 QC5- Inspect part completeness to step on W/O
 Memo

0.00
 0.00
 8

120
120
 Powdercoat
 Powder Coating
 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3
 M126 848
 Memo
 START TIME: 3:10
 FINISH TIME: 3:40

0.00
 0.00
 8
 11/3/19
 DAS 34 9-89

OVEN TEMPERATURE:

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Item ID: D3296-041

Revision ID:

Item Name: Replacement Interior Door For -111

Start Date: 12/17/13 Start Qty: 6.00

Required Date: 12/17/13 Req'd Qty: 6.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

*Q**14/03/20*DAS
36
9-89

140

Small Fab

0.00

140

Small Fab

Memo

Assemble as per Dwg D3296

0.00

Small Fab

*Q**14/03/21*DAS
36
9-89DAS
27
9-89

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

*8**14/3/21*

Work Order ID 110148

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Item ID: D3296-041

Revision ID:

Item Name: Replacement Interior Door For -111

Start Date: 12/17/13 Start Qty: 6.00 *6*

Required Date: 12/17/13 Req'd Qty: 6.00 *6*

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 5T208

0.00

160

Packaging

Memo

0.00

Packaging

8x DAS 14-03-21
28
9-89

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ 14-03-24
MLJ 14-03-24

Picklist Print

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Page 1

Work Order ID: 110148
 Parent Item: D3296-041
 Parent Item Name: Replacement Interior Door For -111
 Comments: IPP C05.10.14Added step 14KJ/EC
 IPP Rev:D Revised Steps 06-11-20 JLM

Start Date: 12/17/13 Required Date: 12/17/13
 Start Qty: 6.00 Required Qty: 6.00

3

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<input checked="" type="checkbox"/> D2137 Decal(No Step)		Manufactured	No			140	Each	10.0000	1	6		14/03/20	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		10						B110767	(7x)
				108061		4						B113741	(1x)
				90854		6							
D2419 Handle		Manufactured	No			140	Each	9.0000	1	6		14/03/20	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		9						B115052	(8x)
				109757		9							
D2462 Seal \$Per Foot		Manufactured	No			140	f	329.7998	2.8166	16.8996		14/03/20	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST402		329.7998						22.5328x	
				48530		13.7336						11.5776	
				98802		316.0662							
D3161-7 Hinge 14.0"		Manufactured	No			100	Each	6.0000	1	6		14/03/13	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST031		6						B113177	(3x)
				102989		2							
				105376		2						B113772	(5x)
				109543		2							

Picklist Print

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Page 2

Work Order ID: 110148

Parent Item: D3296-041

Parent Item Name: Replacement Interior Door For -111

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 6.00

Required Qty: 6.00

D3161-9 Manufactured No
Hinge 17.0"

100 Each 4.0000

1 6

DAS
36
9-89

14/03/20

Location

Loc Qty

Loc Code

ST031

4

108134

1

109621

2

95970

1

D3296-1 Manufactured No
Door Panel

100 Each 2.0000

1 6

DAS
36
9-89

14/03/13

Location

Loc Qty

Loc Code

ST233

2

106194

2

D3296-3 Manufactured No
Door Panel

100 Each 0.0000

1 6

B113088 (8x)

B110269 (6x)
B113169 (2x)
14/03/13

DAS
36
9-89

MS20470AD4-4 Purchased No
Rivet, Universal Head

140 Each 1,579.0000

25 150

14/03/13

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

1

121652

1

ST336

1578

116188

68

118614

129

122027

188

m125807

73

m126275

1120

M128401
200x

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 110148

Parent Item: D3296-041

Parent Item Name: Replacement Interior Door For -111

MS20470AD4-6

Purchased

No

RIVET

100

Each

1,369.0000

1

6

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 6.00

Required Qty: 6.00

DAS
36
9-89

14/03/20

Location

Loc Qty

Loc Code

GA

3

118927

3

ST306

1273

m127305

1273

ST336

62

125654

62

ST505

31

123021

31

NAS1149DN632J

Purchased

No

Washer

140

Each

404.0000

1

6

DAS
36
9-89

14/03/20

Location

Loc Qty

Loc Code

ST293

393

123900

5

M126084

282

M126254

6

M127255

100

ST510a

11

125646

11

December-17-13 9:16:18 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

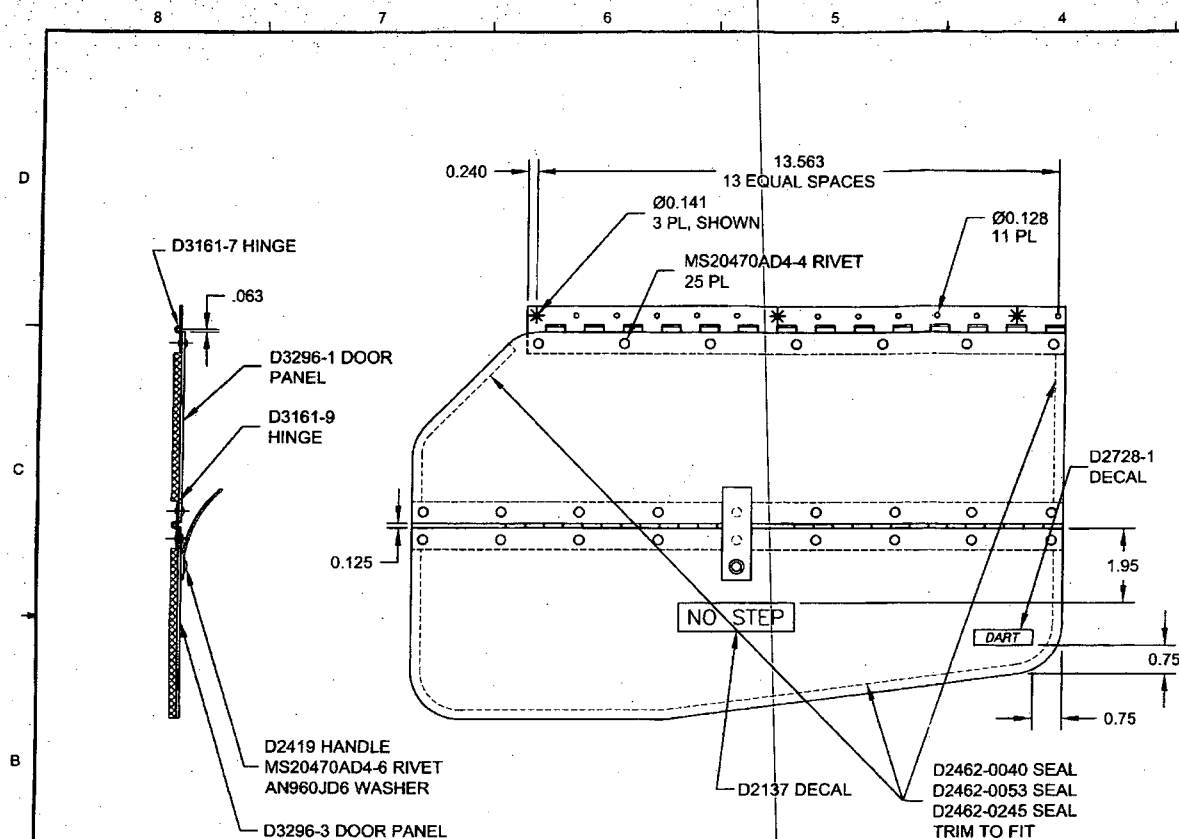
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------



D3296-041 DOOR ASSEMBLY

D3296-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
- 9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

QTY	PART NUMBER	DESCRIPTION
X	D3296-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

B	ADD D3296-041B. REF. PAR12-223.	MB	12.11.15
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

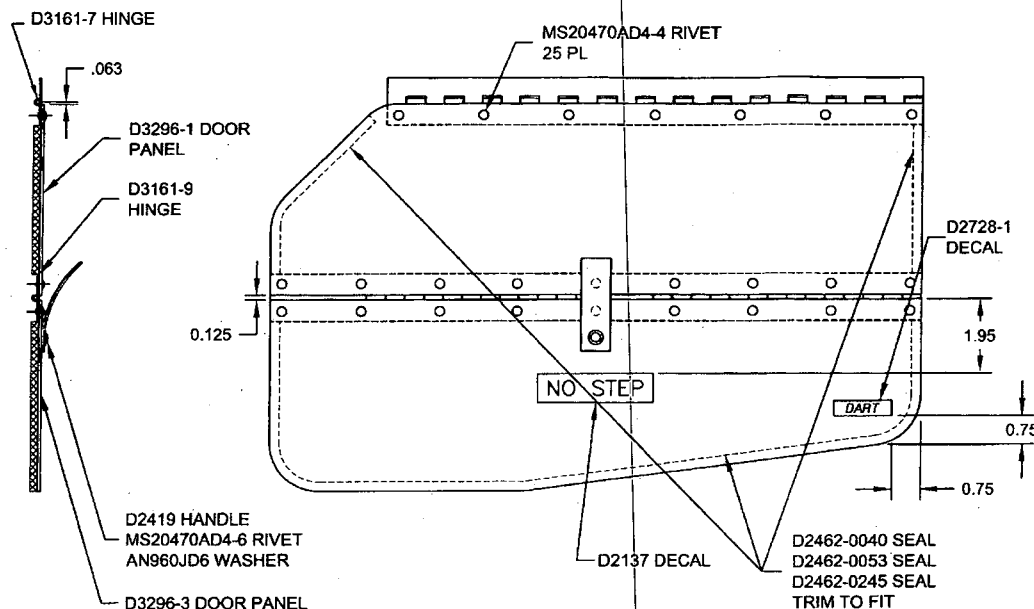
DRAWING NO. D3296
TITLE DOOR ASSEMBLY
REV. B
SHEET 1 OF 3
SCALE NTS

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110148 MCT
13-12-18

RELEASED
2012-11-21

QTY -041B	PART NUMBER	DESCRIPTION
X	D3296-041B	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET



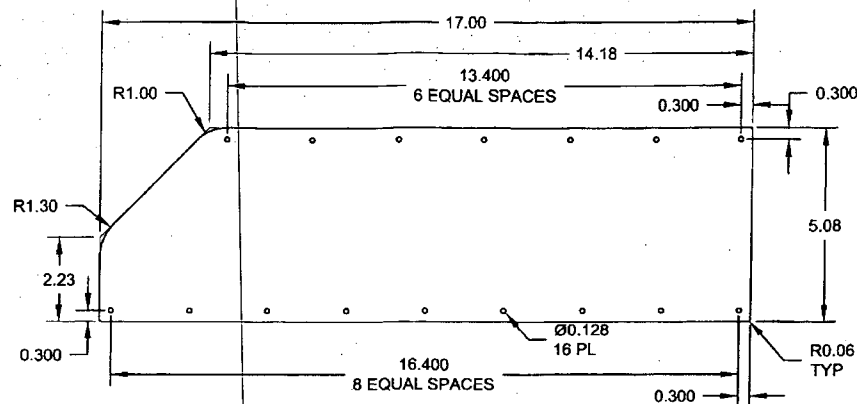
D3296-041B DOOR ASSEMBLY, BLANK

D3296-041B NOTES:

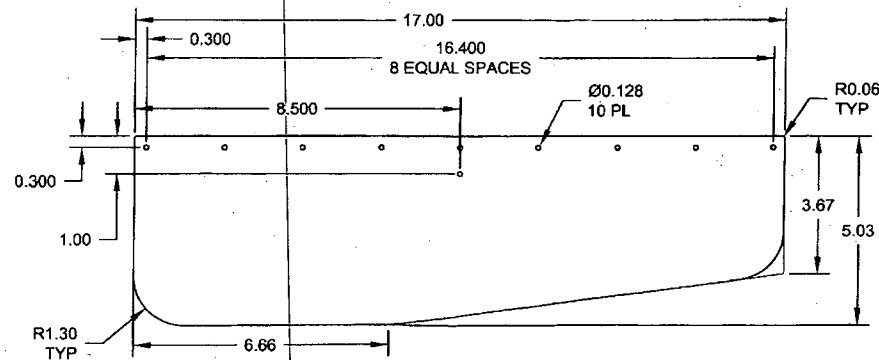
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
- 9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

RELEASED
2012-11-21
WMD

DESIGN	99	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D3296	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	DOOR ASSEMBLY	NTS
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D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

RELEASE
2012-11-21
WFO

D3296-1/-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3296-1 = 0.52 lbs; D3296-3 = 0.50 lbs

DESIGN	99	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	J	D3296	SHEET 3 OF 3
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